

# Job Traveler

Job Number: 231475-01



Due Date: 09/15/2023

Sold INDUSTRIAL PIPING SPECIALIST  
To: P.O. BOX 581270  
TULSA, OK 74158

Ship IPS (Struthers)  
To: 100 South Bridge ST BLG C  
Struthers, OH 44471  
United States

Order No: 231475

Dated: 08/03/2023

Quote No: 19001

Customer: INDUST212830

PO Num: STP12607X

Ship Via: FEDEX FREIGHT COLLECT

Priority: 3 - STANDARD

Part Number: \*3CRXXXXXX

Product Code: CONCENTRIC REDUCER

Description: CR 42X36 .375 X .375-  
WPB

Master Job No:

Total Qty Open: 8 EA

Qty Posted: 0 EA

Qty To Make: 8

Start Date: 08/14/2023

Phone: 9,184,379,100

Contact: GENO COLUMBO

Fax:

## Job Notes

BCLO  
B10637  
PIPE SHOP TRAVELER 255-2023  
CUT (8) PCS 26" FROM (2) 106" CYLS, COMPLETE CYL ALLOCATED, RECORD REMAINING DROP,  
DIGITAL COPY OF TRAVELER EXISTS

## Routing

### Routed By:

Quantity 8

| Step No | Work Cntr / Vendor     | Setup                              | Cycle | Total | Pieces   | --- Scheduled --- |            | Run      |
|---------|------------------------|------------------------------------|-------|-------|----------|-------------------|------------|----------|
| Dept    | Operation              | Time                               | Time  | Time  | Per Hour | Start             | End        | Quantity |
| 10      | PIPE 3<br>PLATE BURN   | Burning Table<br>Plate Burn        |       |       |          | 08/14/2023        | 08/14/2023 | 8        |
| 20      | PIPE 6<br>FURNACE HEAT | Pipe Furnace<br>Furnace heating    |       |       |          | 08/16/2023        | 08/16/2023 | 8        |
| 30      | PIPE 4<br>BIG ROLL     | Big Roller<br>Roll on large roller |       |       |          | 08/16/2023        | 08/16/2023 | 8        |

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Report Generated: 08/03/2023 2:18:56 PM

Page 1 of 4

|                                                                                    |                                                                                     |                                       |                       |   |
|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|---------------------------------------|-----------------------|---|
| 40                                                                                 | PIPE 7<br>STRING UP                                                                 | Initial Weld<br>String-up             | 08/16/2023 08/16/2023 | 8 |
|    |    |                                       |                       |   |
| 50                                                                                 | PIPE 8<br>ID WELD # 1                                                               | ID Weld # 1<br>ID Weld                | 08/16/2023 08/16/2023 | 8 |
|    |    |                                       |                       |   |
| 60                                                                                 | PIPE 12<br>PIPE GOUGE                                                               | Pipe Gouge<br>Pipe gouge              | 08/16/2023 08/16/2023 | 8 |
|    |    |                                       |                       |   |
| 70                                                                                 | PIPE 5<br>WELD PREP                                                                 | Grind After Gouge<br>Weld prep        | 08/16/2023 08/16/2023 | 8 |
|    |    |                                       |                       |   |
| 80                                                                                 | PIPE 9<br>OD WELD                                                                   | OD Weld<br>OD Weld                    | 08/21/2023 08/21/2023 | 8 |
|   |   |                                       |                       |   |
| 90                                                                                 | PIPE 4<br>BIG ROLL                                                                  | Big Roller<br>Re-roll on large roller | 08/21/2023 08/21/2023 | 8 |
|  |  |                                       |                       |   |
| 100                                                                                | FORGE 10<br>CYLINDER CUT                                                            | Cylinder Cut<br>Cylinder Cut          | 08/28/2023 08/29/2023 | 8 |
|  |  |                                       |                       |   |
| 110                                                                                | FORGE 4<br>HAMMER                                                                   | Large Hammer<br>Hammer                | 09/11/2023 09/18/2023 | 8 |
|  |  |                                       |                       |   |
| 120                                                                                | FORGE 7<br>HEAT TREAT                                                               | Heat Treat<br>Heat Treat              | 09/18/2023 09/20/2023 | 8 |
|  |  |                                       |                       |   |

8



8



8



8



8



8



8



Page 3 of 4

## Marking Information:



***FLEET-LINE***

MADE IN USA  
STEEL FORGINGS

BCLO  
42X36  
.375X.375  
WPB

# Pipe Shop Traveler Reducer Cyl.

255-2023

8/3/2023

☐ Pipe Shop Copy

☐ Pipe Shop Original

|            |                             |               |           |          |           |
|------------|-----------------------------|---------------|-----------|----------|-----------|
| Customer   | IPS                         | SFI Order No  | 231475-01 | Due Date | 8/18/2023 |
| Part       | 42.000 OD X 0.750 X 106.000 | Ship Date     | 9/15/2023 | NoPcs    | 2         |
| Plate Size | 0.750 X 129.591 X 106.000   | Code          | BCLO      | Test No  |           |
| Heat No.   | 2603522                     |               |           |          |           |
| Material   | A516-70                     | Test Material |           |          |           |

Cut 2 Plate(s) 0.750 X Thick X 129.591 Width X 106.000 Length 2922 Lbs.

Per Sketch # 5954

From ( 1 ) Plate(s) 0.750 Thick X 120.000 Wide X 404.000 Long

Stamp Plates With Heat Code

BCLO

Scarf to 129.591 + 1/8" -0" Per Sketch Below

Condition Grind Weld Bevels

Roll Hot To 42.000 " O.D.

Tack Weld Using 5/32 " Dia. E7018M LH-75 Electrodes Per Procedure # SMAW-CS-142 REV. 2

Use Weld Procedure SAW-CS-120 REV. 6

Weld I.D. Using 5/32 " Dia. LINCOLN L-50 Wire and LINCOLN 865 Flux.

Backgouge to Sound Metal and Condition Grind O.D. Weld Groove

Weld O.D. Using 5/32 " Dia. LINCOLN L-50 Wire and LINCOLN 865 Flux.

Hot Reroll to Roundup

Torch Cut Into 4 Pcs @ 26 Inches

Paint Mark on Cylinder IPS

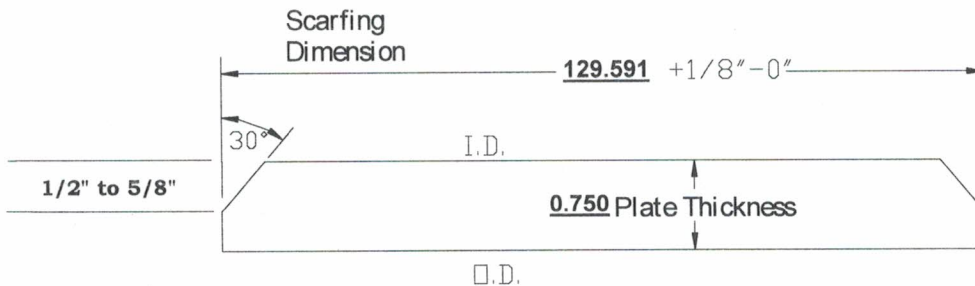
231475-01

Stamp Each Cylinder in (2) Places With Heat Code

BCLO

Fitting Description: (8) CR 42X36 WPB

Comments:



FORM BY HAMMER

**IF ORDER SIZE IS LARGER THAN FURNACE LOAD, SERIALIZE UNDER CUTTER STAMP PRIOR TO HEAT TREAT**

HEAT TREATMENT PER QCP 8.1 REV.1: (WITH TEST MAT'L B- \_\_\_\_\_ )

NORMALIZE 1/2 HR @ 1650°F **AIR COOL** FURNACE LOAD # \_\_\_\_\_

SHOTBLAST TO NEAR WHITE FINISH

**100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION)** \_\_\_\_\_

MACHINE PER B16.9-2018

36 in. (SMALL) END-STRAIGHT BORE I.D. TO 34.500 ± 1/8  
(FACE, TAPER BORE, AND BEVEL)

CONDITION GRIND

STAMP PER A-234 WPBW

HARDNESS TEST AT LEAST 2 PIECES IF QUANTITY IS 2 OR MORE - 197BHN MAX \_\_\_\_\_

PAINT

PAINT MARK: \_\_\_\_\_

END PROTECT/PALLETIZE

FORM BY HAMMER

**IF ORDER SIZE IS LARGER THAN FURNACE LOAD, SERIALIZE UNDER CUTTER STAMP PRIOR TO HEAT TREAT**

HEAT TREATMENT PER QCP 8.1 REV.1: (WITH TEST MAT'L B- \_\_\_\_\_ )

NORMALIZE \_\_\_\_\_ HR @ 1650°F **AIR COOL** FURNACE LOAD # \_\_\_\_\_

SHOTBLAST TO NEAR WHITE FINISH

**100% RADIOGRAPH WELD SEAM PER SPEC. XL-RT-100 (LATEST REVISION)** \_\_\_\_\_

MACHINE PER B16.9-2018 **IF THRU-BORE, ACTUAL ID:** \_\_\_\_\_

\_\_\_\_\_ (SMALL) END-STRAIGHT BORE I.D. TO 0.000 ± .06  
(FACE, THRU BORE, AND BEVEL)

CONDITION GRIND

STAMP PER A-234 WPBW

HARDNESS TEST AT LEAST 2 PIECES IF QUANTITY IS 2 OR MORE - 197BHN MAX \_\_\_\_\_

PAINT

PAINT MARK: \_\_\_\_\_

END PROTECT/PALLETIZE